

Date: Monday, 23/03/2009 9:54:32 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BELT GUIDE
 Job Number : 46657
 Estimate Number : 13016
 P.O. Number :
 This Issue : 23/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 43356
 Part Number : D36403
 Drawing Number : D3640 REVA
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 07/04/2009 Qty: 14 Um: Each
 Written By :
 Checked & Approved By : JLD 09.03.23
 Comment : Est Rev:A New Issue 07-01-15 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELINB075X1250 Delrin Bar



Comment: Qty.: ~~0.4200~~ 4.655 f(s)/Unit Total: 2.5200 f(s)

Black Delrin Bar

1.250" X .750"

BATCH: 4102916 X11M14535 X6Inf 09/03/25

(17)

2.0 BAND SAW BAND SAW



Comment: Cut blank 3.8" long

Inf 09/03/25

(12)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: A

2-Deburr and Blend rad intersection with deburring tool.

DJP 09/03/28

(15)

PTO →

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 09/03/28

(15)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

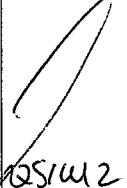
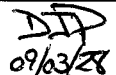
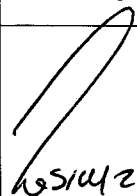

K.A

(15)

09/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3640-3 PAR #: N/A Fault Category: Prod / Machined Parts NCR ☒ Yes No DQA: D Date: 05/04/03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 05/04/03

NCR: <u>46657</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/28	#3.0	2 parts lifted from the jaws when facing the part to its size caused by bitted up of material in 1 inch cutter process		2 parts Scrap No Replace.	 09/03/28	L.A 09/03/30		 10/05/30

NOTE: Date & initial all entries

Date: Monday, 23/03/2009 9:54:33 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELT GUIDE

Job Number: 46657

Part Number: D36403

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 243

SS 09/05/30 (XRS)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 JS

Job Completion



MF 09-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

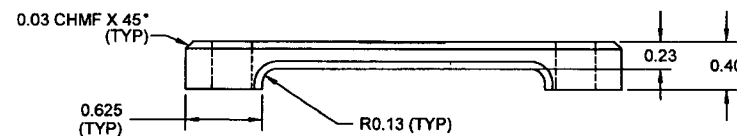
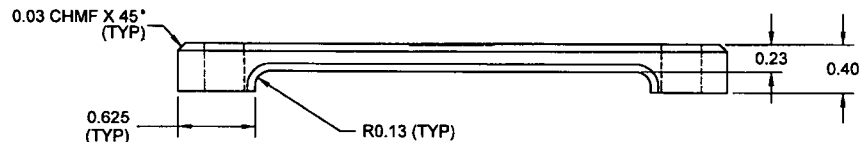
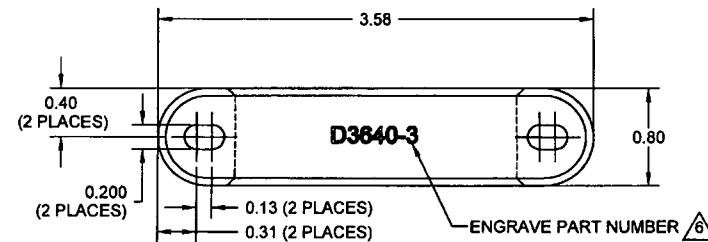
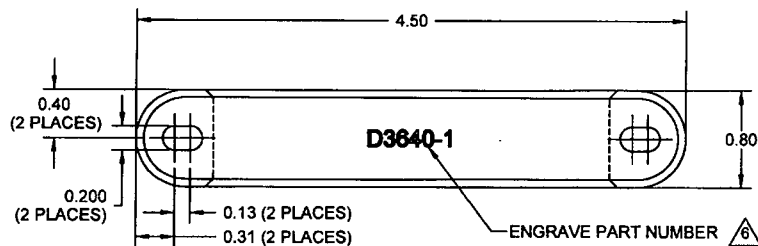
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

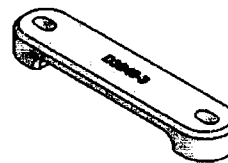


D3640-1 BELT GUIDE
(WAS GENEVA P/N G10605-1)

D3640-3 BELT GUIDE
(WAS GENEVA P/N G10605-2)

NO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
ENGINEERING
RETURN TO
SHOP COPY

- NOTES:
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs



RELEASED
07-09-01

A	NEW ISSUE: REPLACES G10605	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	07.07.27		

DART AEROSPACE USA, INC.	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3640	SHEET 1 OF 1
TITLE	SCALE
BELT GUIDE	1:1

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.